

CLAIMS:

1. A method of manufacturing a vibration mount for machinery,
said method comprising the steps of:-
 - 5 locating spaced metal mounting brackets in a mould to form a cavity therebetween;
introducing into said cavity a liquid MDI polyurethane cushioning material; and,
curing said polyurethane cushioning material at an elevated
10 temperature until said cushioning material is at least partially cross linked and bonded to said mounting brackets.
 2. A method as claimed in claim 1 wherein at least those surfaces of said mounting brackets intended to be bonded to said polyurethane cushioning material are coated with a primer surfacing before being located
15 in said mould.
 3. A method as claimed in claim 2 wherein said primer surfacing is at least partially cured at an elevated temperature prior to introduction into said cavity of said cushioning material.
 4. A method as claimed in claim 1 wherein said vibration mounts
20 are postcured at an elevated temperature in the range of from 75°C to 150°C for a period of from 12 hours to 24 hours.
 5. A method as claimed in claim 1 wherein said vibration mounts are conditioned by storage in a temperature range of from 15°C to 35°C for a period of from 15 to 45 days after removal from said mould.
 - 25 6. A method as claimed in claim 2 wherein said mounting

brackets are grit blasted prior to coating with primer surfacing.

7. A method as claimed in claim 6 wherein said mounting brackets are electro-polished after bonding of said cushioning material thereto.

5 8. A vibration mount for machinery, said mount comprising:-
spaced metal mounting brackets, each mounting bracket being adhesively anchored to a cured MDI polyurethane cushioning material cast therebetween, said metal mounting brackets having a bright corrosion resistant metal finish.

10 9. A vibration mount as claimed in claim 8 wherein said polyurethane cushioning material is at least partially cross-linked.

10. A vibration mount as claimed in claim 8 wherein said polyurethane cushioning material is comprised of a polyester based, MDI terminated prepolymer reacted with a low molecular weight polyol.

15 11. A vibration mount as claimed in claim 10 wherein said low molecular weight polyol is a diol.

12. A vibration mount as claimed in claim 11 wherein said diol is an aromatic diol or an aliphatic diol.

13. A vibration mount as claimed in claim 8 wherein said cured
20 polyurethane cushioning material has a Shore A hardness in the range 75-90.

14. A vibration mount as claimed in claim 13 wherein said cured polyurethane cushioning has a Shore A hardness in the range 75-85.

15. A vibration mount as claimed in claim 14 wherein said cured

polyurethane cushioning has a Shore A hardness in the range 78-82.

16. A vibration mount as claimed in claim 8 wherein said cured polyurethane material is coloured.